

5/08

DART AEROSPACE LTD		Work Order:	22220
Description: 206 A/B High Gear Web		Part Number:	D2654-3
05.01.13 E1 405.01.13			
Drawing: D2654 Rev. 2 DEO 9136		Qty:	4

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	HA	05.01.13	4
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-5 Web B2433	DP	05-8-22	4
3	METAL	Cut D2600-5 to length as per Dwg D2654	DP	05-8-22	4
4	METAL	Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654	Pmc	05-8-24	4
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	Pmc	05-8-29	4
6	METAL	Deburr holes and ends	Pmc	05-8-29	4
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	Pmc	05-8-30	4
8	QC	Inspect Level 5	J	05-09-07	4
9	METAL	Identify and stock	Pmc	05-9-7	4
10	EXPEDITING	Close Work Order Inspect level 21 Cost/part: 44.18 SAC 05/09/08 4	DP	05/09/08	4

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	02-05-27

RELEASED

02/05/11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
		1 1 1 1						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/09/08

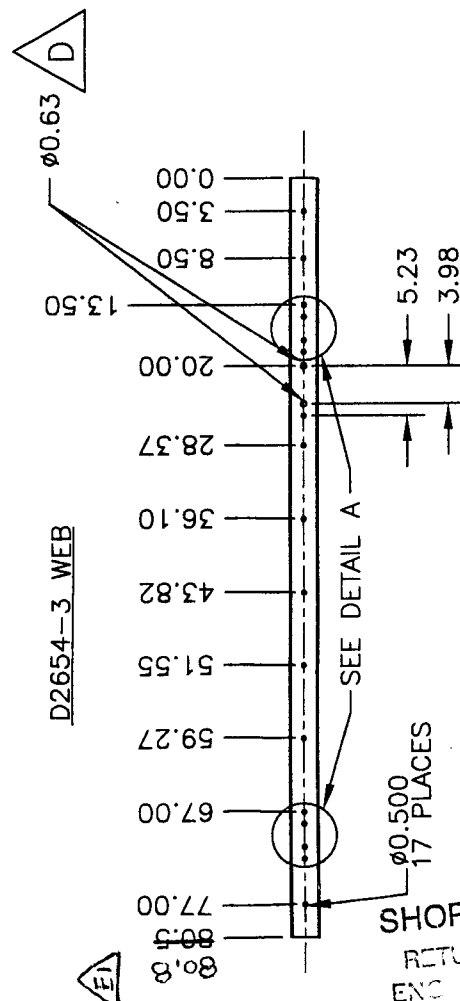
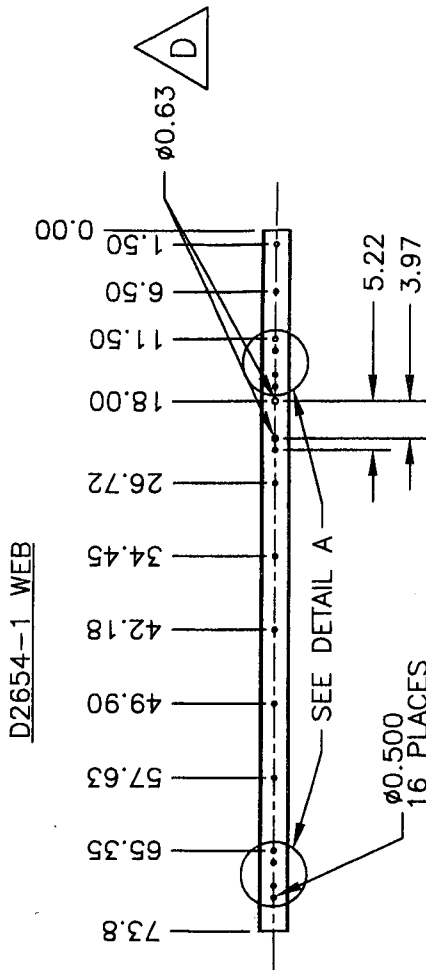
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO.	REV. E
				D2654	SHEET 1 OF 2
DATE	04.05.26			TITLE	SCALE
				WEB	1:20
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	<i>CP</i> 04.08.04	PER TOOLING; 80.8 WAS 80.5			

RELEASED
04.06.22



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SUBMIT
WORK ORDER
NO. 22220

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DM	APPROVED KE	DRAWING NO. DEO 9136	REV. A SHEET 1 OF 1
DATE 99.02.26	TITLE 206 SKIDTUBE WEB LENGTH CHANGE		SCALE NTS
A	99.02.26	NEW ISSUE	

DART ENGINEERING ORDER

TO AMEND DWGS: D2650 REV. C
D2654 REV. D

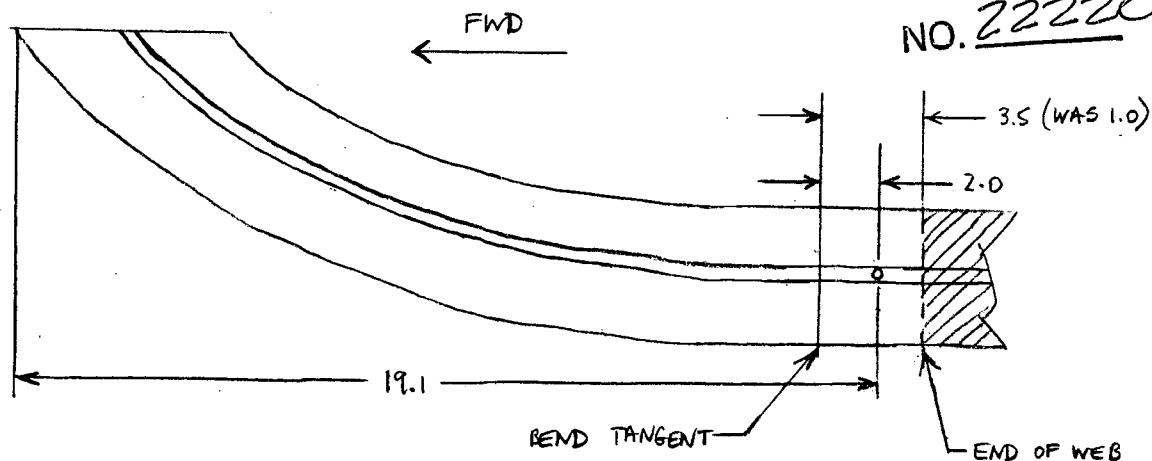
TO FACILITATE BENDING D206-642 SKIDTUBES IN-HOUSE, ALL WEBS CALLED UP ON DWG D2654 SHOULD BE SHORTENED BY 2.50" AT THE FWD END. THIS WILL ELIMINATE THE NEED TO DRILL THE FWD HOLE ON ALL WEBS SHOWN ON DWG D2654. THE REVISED LENGTHS ARE AS FOLLOWS:

PART NO.	LENGTH WAS	LENGTH NOW
D2654-1	76.35	73.85
D2654-3	83.35	80.85
D2654-5	97.25	94.75
D2654-7	118.50	116.00

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REVISION

THE BENDING DETAIL ON PAGE 7 OF DWG. D2650 WILL NOW BE AS FOLLOWS:

WORK ORDER
NO. 22220



IT IS ACCEPTABLE TO ENGINEERING TO HAVE A MAXIMUM REDUCTION IN DIAMETER OF 0.150" FWD OF THE WEB IN THE BENT PORTION OF THE TUBE.

RELEASED
99.03.02 DS

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 13, 2005
10:56 am

Work Order No : 0022220
Project Name : D2654-3
Project For : WK508
Work Order Type : Main
Main WO Number :
House Part Number : D2654-3
Description : 206 I-Beam (Web)
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 01-13-05
Est Finish Date : 02-21-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00